

# Work Order ID 82637

**\*82637\***

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April-04-12 10:51:04 AM

Item ID: D4271-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Beam Assembly  
 Start Date: 04/04/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4271	D								
100		0.00							
<b>*100*</b>									
Small Fab	Memo	0.00							
Small Fab	1- Pick and Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location <u>164</u>	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging									

4X 12/05/11  
4 12/05/11  
4 12/05/11

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	Ely	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

**\*82637\***

Page 2

**\*N900040100\***

**\*NS1\***

Stop \*NS2\*

**\*4\***

**\*4\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

0.00

0.00

## Memo

12/5/14 J

ME  
12-05-14

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April-04-12 10:51:08 AM

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Work Order ID: 82637

**\*82637\***

Parent Item: D4271-011

**\*D4271-011\***

Parent Item Name: Fwd Beam Assembly

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC  
11.01.26 RevB dwg EC verified by:DD  
per PD1 EC verified by:JLM

IPP RevA  
IPP RevC 11.07.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-025 <b>*D4271-025*</b> End Fitting Assembly Fwd Beam		Manufactured	No			100	Each	1.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST512				1					
					72266			1					
D4275-1 <b>*D4275-1*</b> Fwd Beam		Manufactured	No			100	Each	4.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st1638				2					
					74709			2					
				ST168				2					
					80594			2					
AN3C12A <b>*AN3C12A*</b> Bolts		Purchased	No			100	Each	314.0000	6	24			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				41					
					120449			41					
				ST351				273					
					117514			4					
					118112			5					
					118451			22					
					119510			1					
					120423			191					
					121259			50					

B12/05/11  
B82641 (4x)

B12/05/11

2  
2

B12/05/11

24

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

# Picklist Print

April-04-12 10:51:08 AM

Page 2

Work Order ID: 82637

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

\*82637\*

\*D4271-011\*

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

100

Each

1,528.000

6

24

\*MS21043-3\*

Nut

\*\*

*EB 12/05/11*

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

240

120693

240

ST301

1216

118077

2

118614

164

118686

30

119758

20

121255

1000

*24*

NAS1149C0332R

Purchased

No

100

Each

3,487.000

12

48

\*NAS1149C0332R\*

Washer

\*\*

*EB 12/05/11*

Location

Loc Qty

Loc Code

ST297

513

119736

196

120648

317

ST298

2974

121255

2974

*48*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

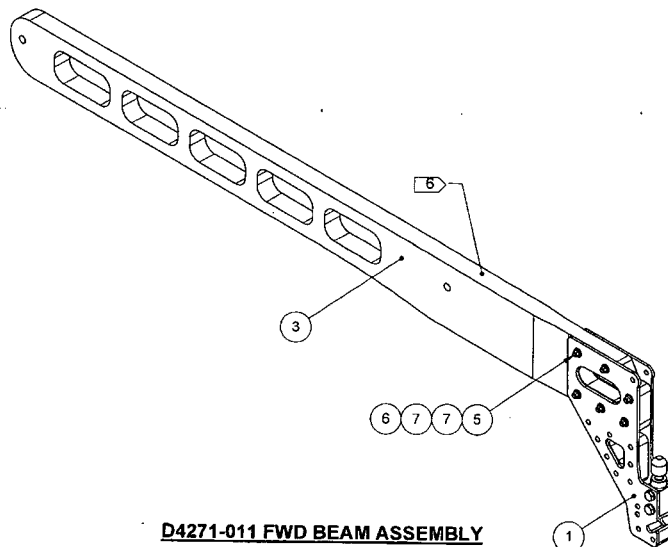
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

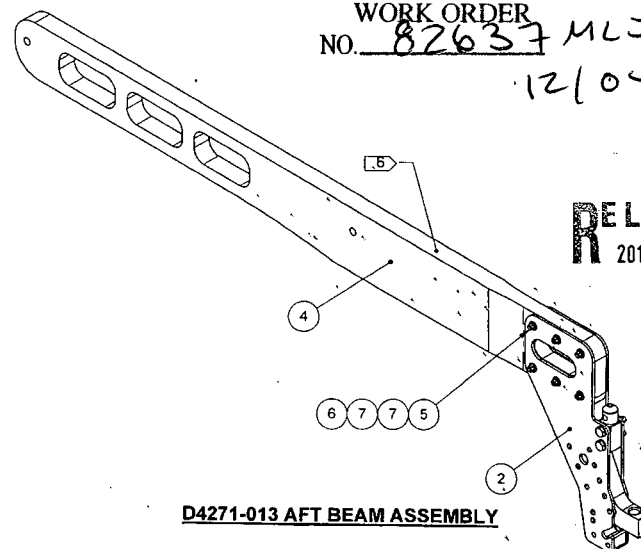
NOTE: Date & initial all entries



ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82637 MLJ  
12/04/04

**RELEASED**  
2011-07-28

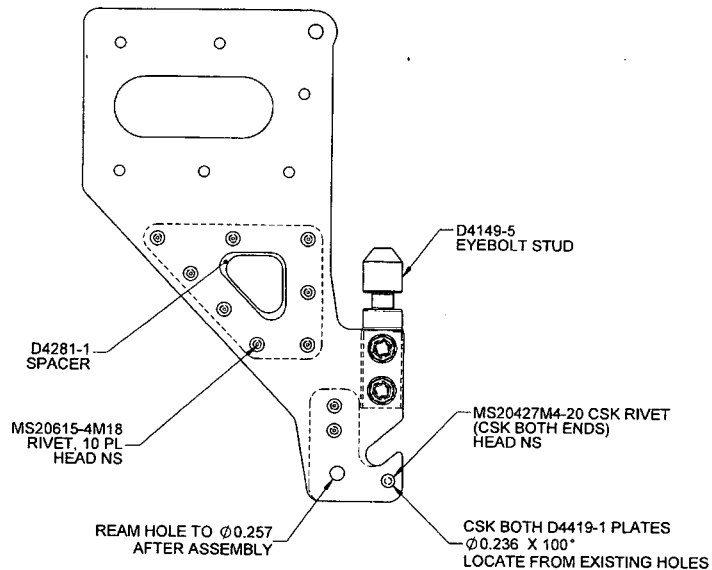
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs  
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4271</b> REV. D SHEET 1 OF 3 TITLE <b>SUPPORT BEAM ASSEMBLIES</b> NTS SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NOISE IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	91		
MFG. APPR.	BE		
APPROVED	140		
DE APPR.	140		
DATE	11.07.14		

82637

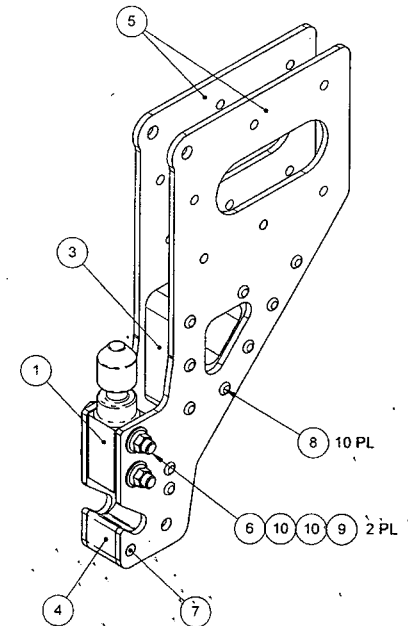
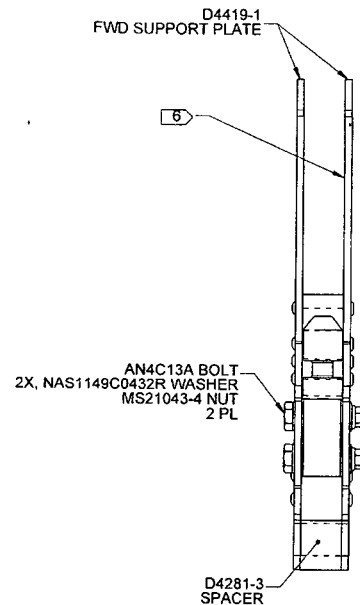
ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



# D4271-025 FWD BEAM END FITTING ASSEMBLY

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs



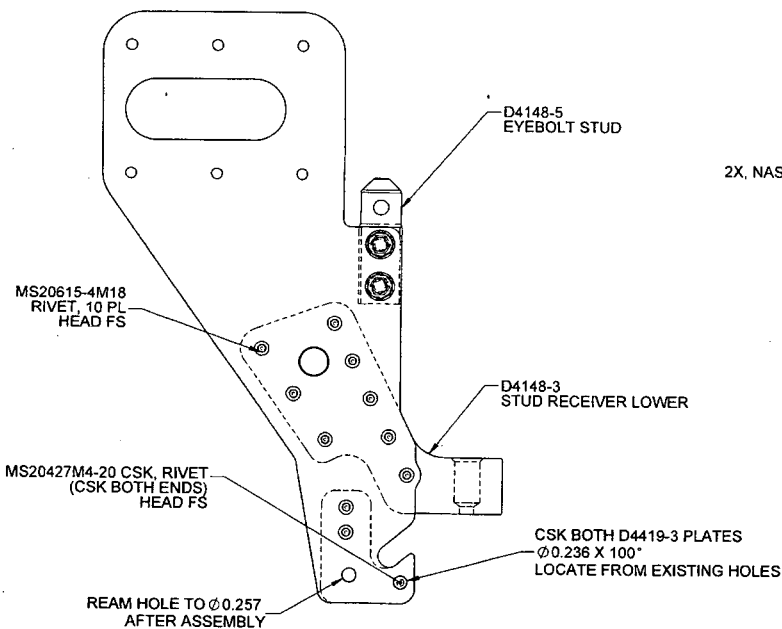
**RELEASED**  
2011-07-28  
JW

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT BEAM ASSEMBLIES</b>	
DATE	11.07.14	NTS	

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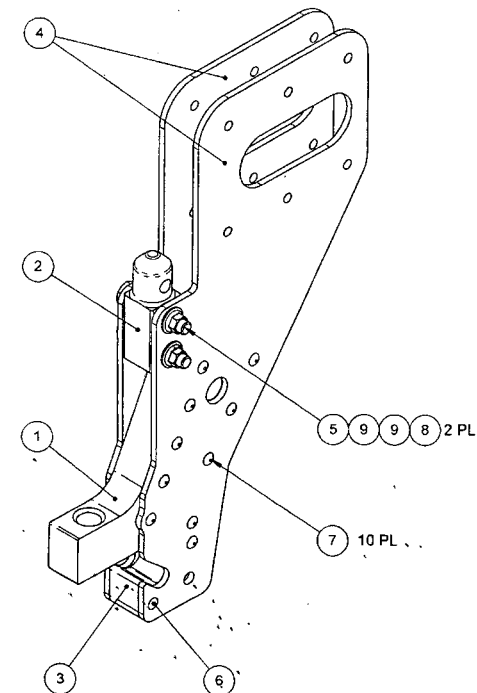
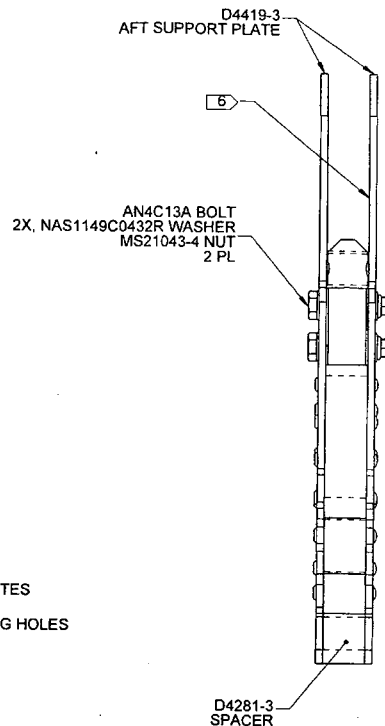
ITEM	QTY	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



**D4271-027 AFT BEAM END FITTING ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



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2011-07-28

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JD	DRAWING NO.	REV. D
MFG. APPR.	E	<b>D4271</b>	SHEET 3 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	<b>SUPPORT BEAM ASSEMBLIES</b>	NTS
DATE	11.07.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	